

April 6

Work Order ID 81024

81024

Page 1

March-06-12 4:25:03 PM

Item ID: D4055-041 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Fuel Tank Assembly
Start Date: 06/03/2012 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 20/03/2012 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/03/06 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4055	C

100 Weld per dwg A/R Aluminum rod Batch: 119725 0.00
120169

100

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

12.03.12 1.0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81024

March-06-12 4:25:03 PM

81024

Page 2

Item ID: D4055-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 06/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00				1	0		BE 12/03/12
110									
QC	Memo	0.00							
Quality Control									
121	Weld per dwg A/R Aluminum rod Batch: 119185	0.00							
121									
Large Fab	Memo	0.00							
Large Fab	1-Weld top D4055-1								
122	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
122									
QC	Memo	0.00							
Quality Control									

119185
120169
12.03.19 1 0
BE 12/03/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

March-06-12 4:25:03 PM

81024

Page 3

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 06/03/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 20/03/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Insp. Stamp

QC5- Inspect part completeness to step on W/O

0.00

123

QC

Memo

0.00

Quality Control

Pressure Test as per dwg D4055

- tested at 4.0 Psi Soap/Water
- filled with water / no leaks

8/2/03/22

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

1- brush alodine on tank. No alodine inside

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

March-06-12 4:25:03 PM

Page 4

NS1

Stop *NS2*

*** 1 ***

*** 1 ***

Customer:

Run Start *NR1*

Stop *NR2*

Date:

**Insp.
Stamp**

0.00

Memo

0.00

Powdercoat

Powder Coating

Mask prior to powdercoat

Start Time: 1630

Oven Temperature: 320°F

Finish Time: 2h00

m118533

180

QC3- Inspect Part Finish

0.00

Memo

0.00

QC

Quality Control

190

0.00

Memo

0.00

Small Fab

Small Fab

Assemble as per dwg & DSI 9577

Feb 23/80

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81024***81024***

Page 5

March-06-12 4:25:03 PM

Item ID: D4055-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 06/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.00

Quality Control

230

Identify as per dwg & Stock Location:

0.00

230

Packaging

Memo

0.00

Packaging

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

12/13/2012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

March-06-12 4:25:07 PM

81024

D4055-041

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
revised pick list EC verifiedby:DD IPP Rev D: 11.06.01 per D4055
revB EC verified by:DD IPP Rev;E 12.02.27 per D4055 revC DD
VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1		Manufactured	No			190	Each	11.0000	1	1			
D3997-1													
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		11							
				79411		1							
				80847		10							
D3997-5		Manufactured	No			190	Each	0.0000	2	2			
D3997-5													
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		90							
				72611		90							
D3997-11		Manufactured	No			190	Each	8.0000	1	1			
D3997-11													
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		8							
				80308		8							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 4:25:07 PM

Page 2

Work Order ID: 81024

81024

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-17

Manufactured No

190 Each

10.0000

1

1

D3997-17

Placard

**

50

Location

Loc Qty

Loc Code

ST141

10

73513

1

80309

9

D3997-29

Manufactured No

190 Each

22.0000

1

1

D3997-29

Placard

**

50

Location

Loc Qty

Loc Code

ST141

22

80845

22

D3997-43

Manufactured No

190 Each

7.0000

1

1

D3997-43

Placard

**

8

Location

Loc Qty

Loc Code

ST141

7

80310

7

D3999-7

Manufactured No

100 Each

11.0000

1

1

D3999-7

Corner

**

12.03.09

Location

Loc Qty

Loc Code

WA014

11

71695

1

75156

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 4:25:07 PM

Page 3

Work Order ID: 81024

81024

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-9 Manufactured No 100 Each 2.0000 1 1

D3999-9

Angle

**

12.03.09

Location Loc Qty Loc Code

WA014

2

71696

2

D3999-11 Manufactured No 100 Each 4.0000 1 1

D3999-11

Earth Tab

**

12.03.09

Location Loc Qty Loc Code

WA

8

WA013

-8

WA014

4

75180

4

D3999-041 Manufactured No 100 Each 1.0000 1 1

D3999-041

Baffle Assembly, Aft

**

12.03.08

Location Loc Qty Loc Code

WA014

1

75230

1

D3999-043 Manufactured No 100 Each 2.0000 1 1

D3999-043

Baffle Assembly, Fwd

**

12.03.08

Location Loc Qty Loc Code

WA

2

78814

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 4:25:07 PM

Page 4

Work Order ID: 81024

81024

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-1 Manufactured No

100 Each

3.0000

1

1

D4000-1

Fuel Supply Fitting

**

12.03.10

Location

Loc Qty

Loc Code

WA

3

80029

3

D4000-5 Manufactured No

100 Each

3.0000

1

1

D4000-5

Fuel Tank Vent Fitting

**

12.03.10

Location

Loc Qty

Loc Code

WA013

3

80030

3

D4000-9 Manufactured No

100 Each

12.0000

3

3

D4000-9

Grommet

**

12.03.09

Location

Loc Qty

Loc Code

WA013

12

78379

12

D4000-043 Manufactured No

100 Each

1.0000

1

1

D4000-043

Drain Fitting Assembly, Fwd

**

12.03.09

Location

Loc Qty

Loc Code

WA

1

78732

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 4:25:07 PM

Page 5

Work Order ID: 81024

81024

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-045

Manufactured No

100 Each

2.0000

1

1

D4000-045

Fuel Pickup Fitting Assembly

**

12.03.09

Location

Loc Qty

Loc Code

WA013

381071 = 1

1

72078

1

WA014

1

71669

1

D4000-041

Manufactured No

100 Each

0.0000

1

1

D4000-041

Drain Fitting Assembly, Aft

D4001-1

Manufactured No

100 Each

5.0000

1

1

D4001-1

Fitting

**

12.03.10

Location

Loc Qty

Loc Code

WA014

5

80031

5

D4008-11

Manufactured No

100 Each

14.0000

1

1

D4008-11

Hinge Half

**

12.03.09

Location

Loc Qty

Loc Code

WA

14

80037

6

80838

8

D4008-041

Manufactured No

190 Each

5.0000

1

1

D4008-041

Fuel Filler Splash Guard Assembly

**

12/3/27

Location

Loc Qty

Loc Code

ST142

5

72792

1

78910

4

March-06-12 4:25:08 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 4:25:08 PM

Page 6

Work Order ID: 81024

81024

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4023-3 Manufactured No

100 Each

6.0000

1 1

D4023-3

Cap and Flange

**

12.03.08

Location

Loc Qty

Loc Code

ST110

2

73514

2

WA

4

80032

4

D4025-1 Manufactured No

100 Each

4.0000

1

D4025-1

Fuel Quantity Sender

**

12.03.08

Location

Loc Qty

Loc Code

ST143

4

71765

1

80033

3

D4055-11 Manufactured No

100 Each

1.0000

1

D4055-11

Tank Front and Bottom

**

12.03.08

Location

Loc Qty

Loc Code

WA014

1

74908

1

D4055-9 Manufactured No

100 Each

0.0000

1

D4055-9

Tank Back

**

12.03.08

D4055-7 Manufactured No

100 Each

1.0000

1

D4055-7

Tank Fwd End

**

12.03.08

Location

Loc Qty

Loc Code

WA

1

73441

1

Shop Packet Print

March-06-12 4:25:08 PM

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 4:25:08 PM

Page 7

Work Order ID: 81024

81024

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4055-5 Manufactured No

100 Each

5.0000

1

1

D4055-5

Tank Upper Cut Out

**

12.03.10

Location

Loc Qty

Loc Code

WA014

5

74907

5

D4055-3 Manufactured No

100 Each

2.0000

1

1

D4055-3

Tank Aft End

**

12.03.10

Location

Loc Qty

Loc Code

WA014

2

75224

2

D4055-1 Manufactured No

100 Each

4.0000

1

1

D4055-1

Tank Top

**

12.03.10

Location

Loc Qty

Loc Code

WA013

4

78820

4

D4057-1 Manufactured No

100 Each

8.0000

3

3

D4057-1

Retaining Ring

**

12.03.09

Location

Loc Qty

Loc Code

WA013

8

71166

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 4:25:08 PM

Page 8

Work Order ID: 81024

81024

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3H5A Purchased No

190 Each

57.0000 5

AN3H5A

Bolt

**

Location

Loc Qty

Loc Code

ST351

57

118112

1

120498

6

120693

50

NAS1149D0363J Purchased No

190 Each

2,174.000 5

NAS1149D0363.J

Washer

**

Location

Loc Qty

Loc Code

ST298

2174

117601

61

118077

1

118612

18

119537

257

120142

267

120308

570

120644

1000

D4404-1 Manufactured No

190 Each

4.0000 1

D4404-1

Cushion

**

Location

Loc Qty

Loc Code

ST242A

4

75181

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 4:25:08 PM

Page 9

Work Order ID: 81024

81024

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4404-5 Manufactured No

190 Each 12.0000 1

D4404-5

Cushion, Fwd

**

Location

Loc Qty

Loc Code

ST242A

12

76899

2

80753

10

D4404-7 Manufactured No

190 Each 8.0000 1

D4404-7

Cushion, Upper Side

**

Location

Loc Qty

Loc Code

ST242A

8

79119

4

80754

4

D4404-9 Manufactured No

190 Each 4.0000 1

D4404-9

Cushion, Lower Side

**

Location

Loc Qty

Loc Code

ST

-4

79120

4

ST242B

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

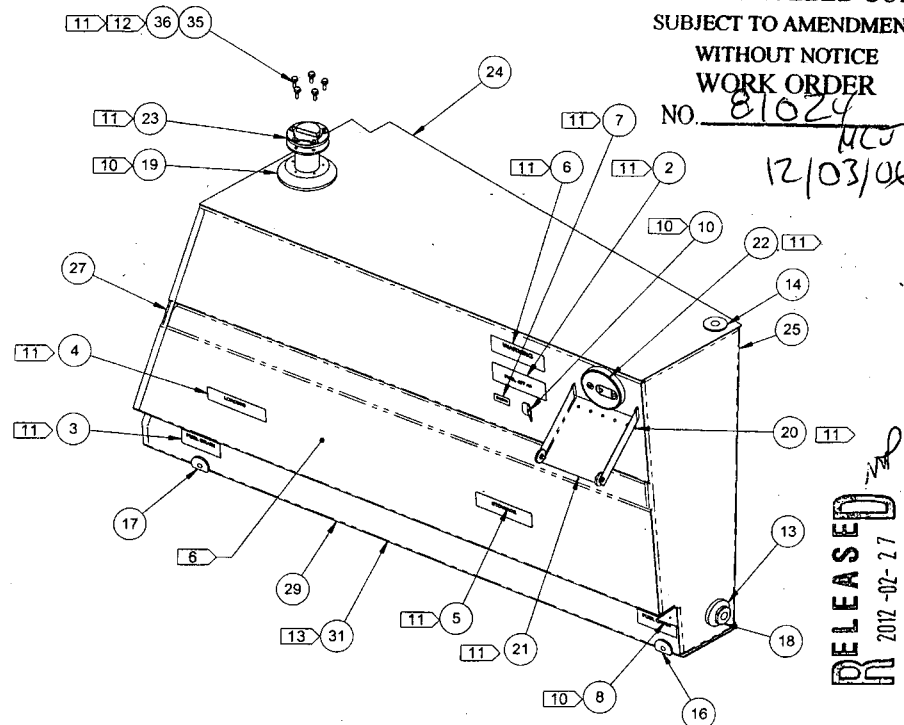
NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	1	D4404-5	CUSHION, FWD
33	1	D4404-7	CUSHION, UPPER SIDE
34	1	D4404-9	CUSHION, LOWER SIDE
35	5	AN3H5A	BOLT
36	5	NAS1149D0363J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK PER QSI 038 4.3. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHIONS AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81024
12/03/06

RELEASED
2012-02-27

C	ADDED ITEMS 32, 33, 34, ZONE B8-1. ADDED NOTE 8, ZONE A8-1. CHANGED POWDER COAT FROM "GREY SANITEX" TO "ANSI 61 GREY". ZN A8-1. DELETED INSTRUCTIONS FOR SLOSHING COMPOUND, ZN A8-3.	DC	12.01.20
B	MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	HS	11.05.12
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	CE	D4055	SHEET 1 OF 15
APPROVED	MG	TITLE	SCALE
DE APPR.	TH	TANK	NTS
DATE	12.01.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

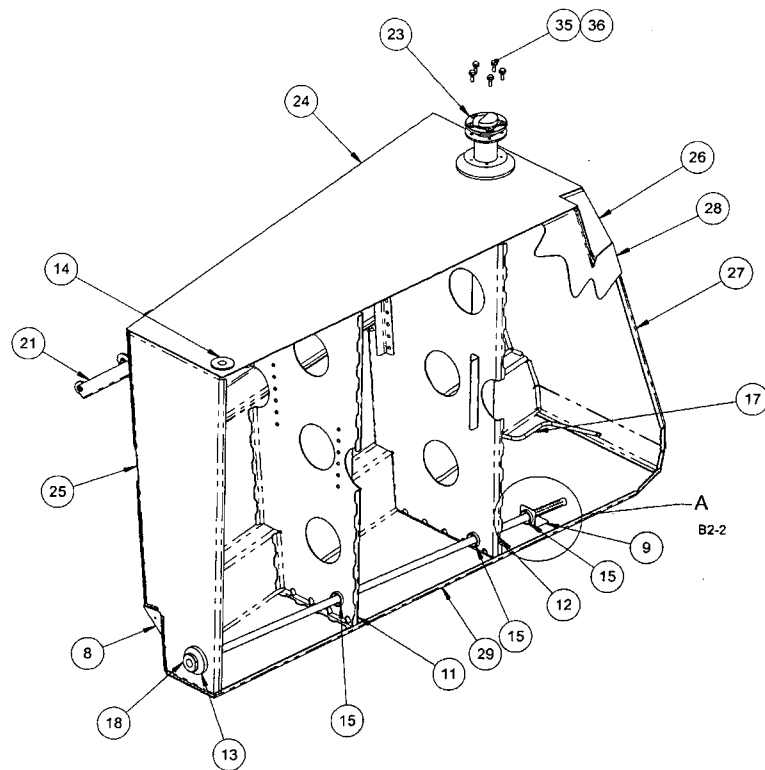
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

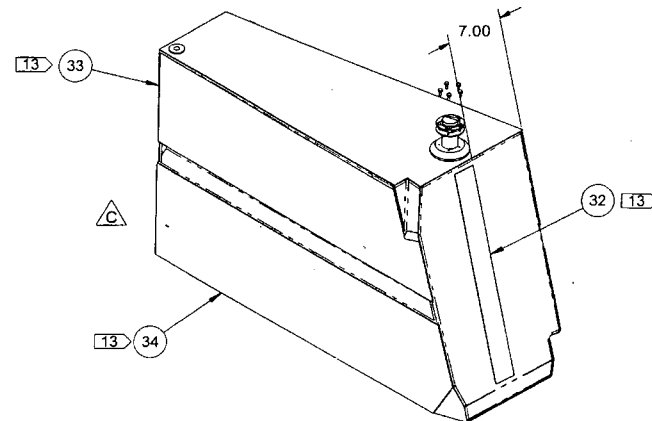
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

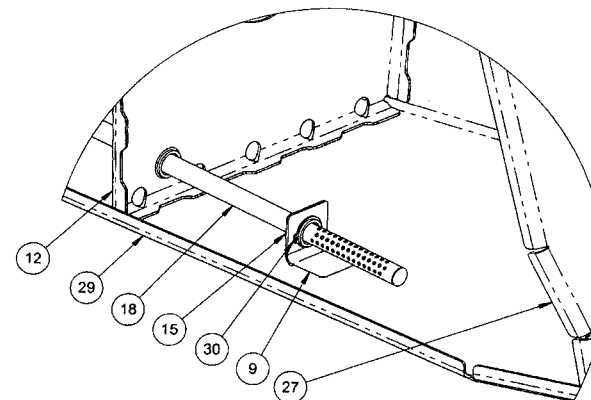
NOTE: Date & initial all entries



**D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL**



81024



**DETAIL A
ROTATED FOR CLARITY
SCALE 2X**

B6-2

RELEASED
2012-02-27

DESIGN		DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO. D4055	REV. C
MFG. APPR.	DC	SHEET 2 OF 15	
APPROVED	DC	TITLE TANK	SCALE
DE APPR.	DC	NTS	
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

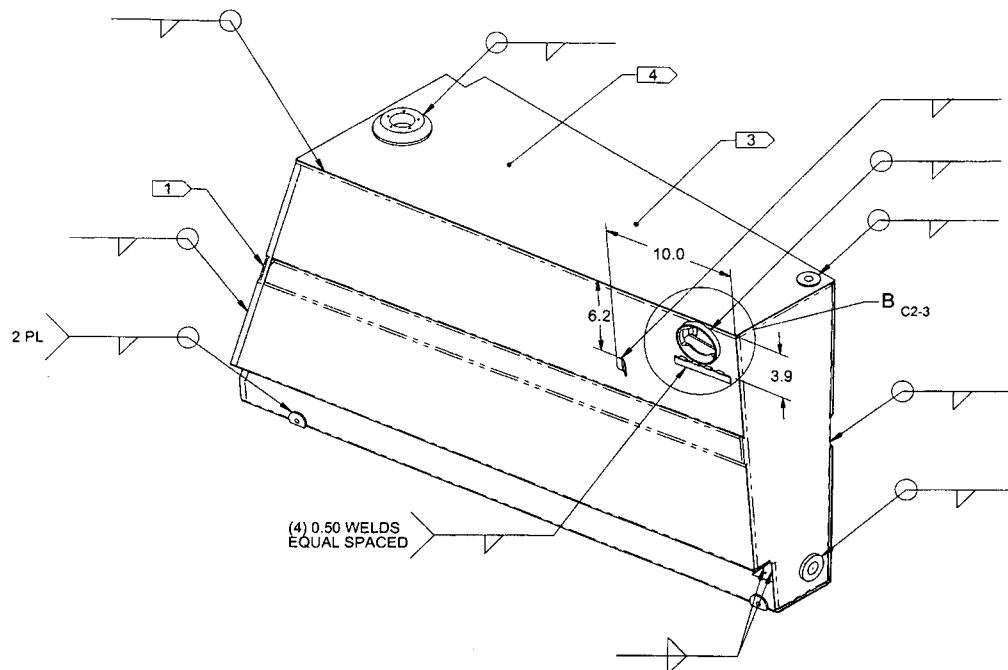
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

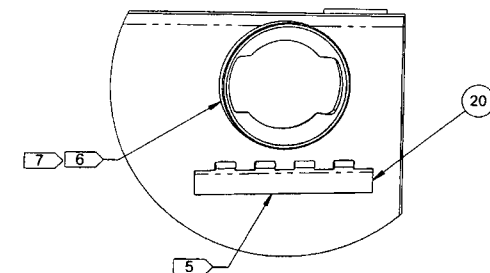


(4) 0.50 WELDS
EQUAL SPACED

D4055-041 FUEL TANK ASSEMBLY WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK



**DETAIL B
ROTATED FOR CLARITY
SCALE 2X**

C4-3

RELEASED
2012-02-27

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4055	SHEET 3 OF 15
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	TANK	NTS
DATE	12.01.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

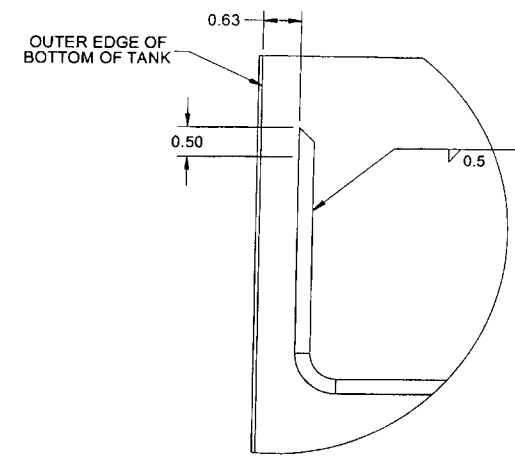
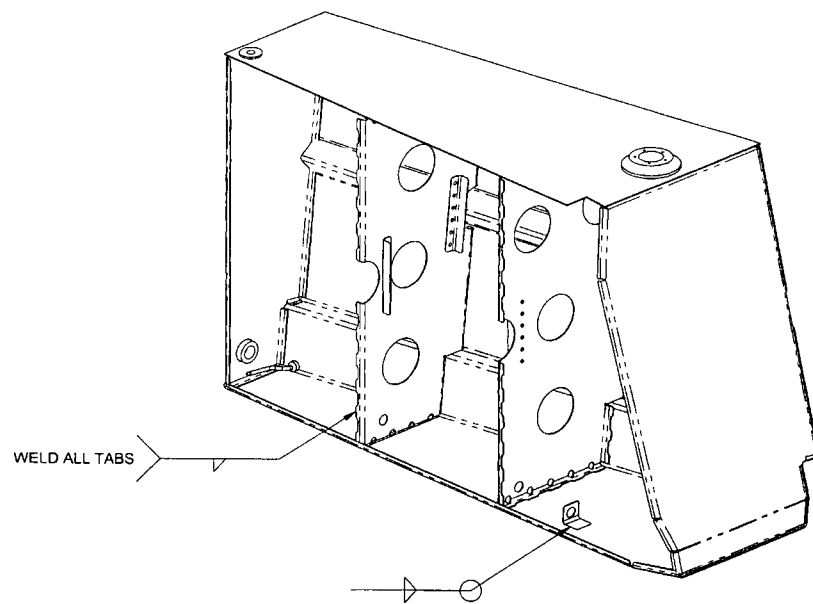
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81024



DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

RELEASED
 2012-02-27
 AM

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4055	REV. C
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 4 OF 15
APPROVED	<i>[Signature]</i>	TANK	SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

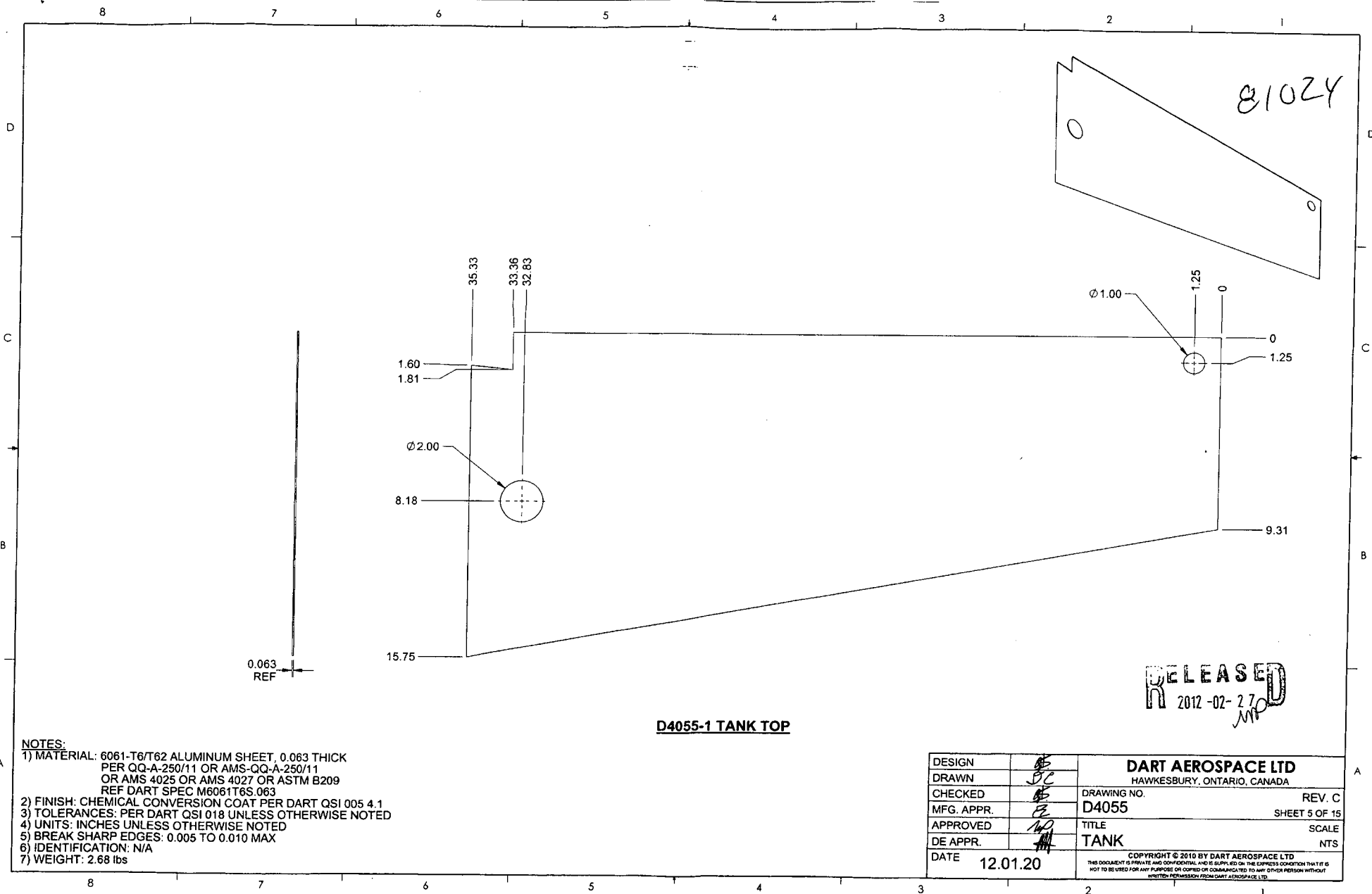
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs

D4055-1 TANK TOP

DESIGN	DES	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DES	DRAWING NO.	REV. C
MFG. APPR.	DES	D4055	SHEET 5 OF 15
APPROVED	DES	TITLE	SCALE
DE APPR.	DES	TANK	NTS
DATE	12.01.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81024



R0.19
TYP
0.50
TYP

D4055-3 TANK AFT END

RELEASED
2012-02-27

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	DL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	FE	D4055	SHEET 6 OF 15
APPROVED	140	TITLE	SCALE
DE APPR.	TH	TANK	NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

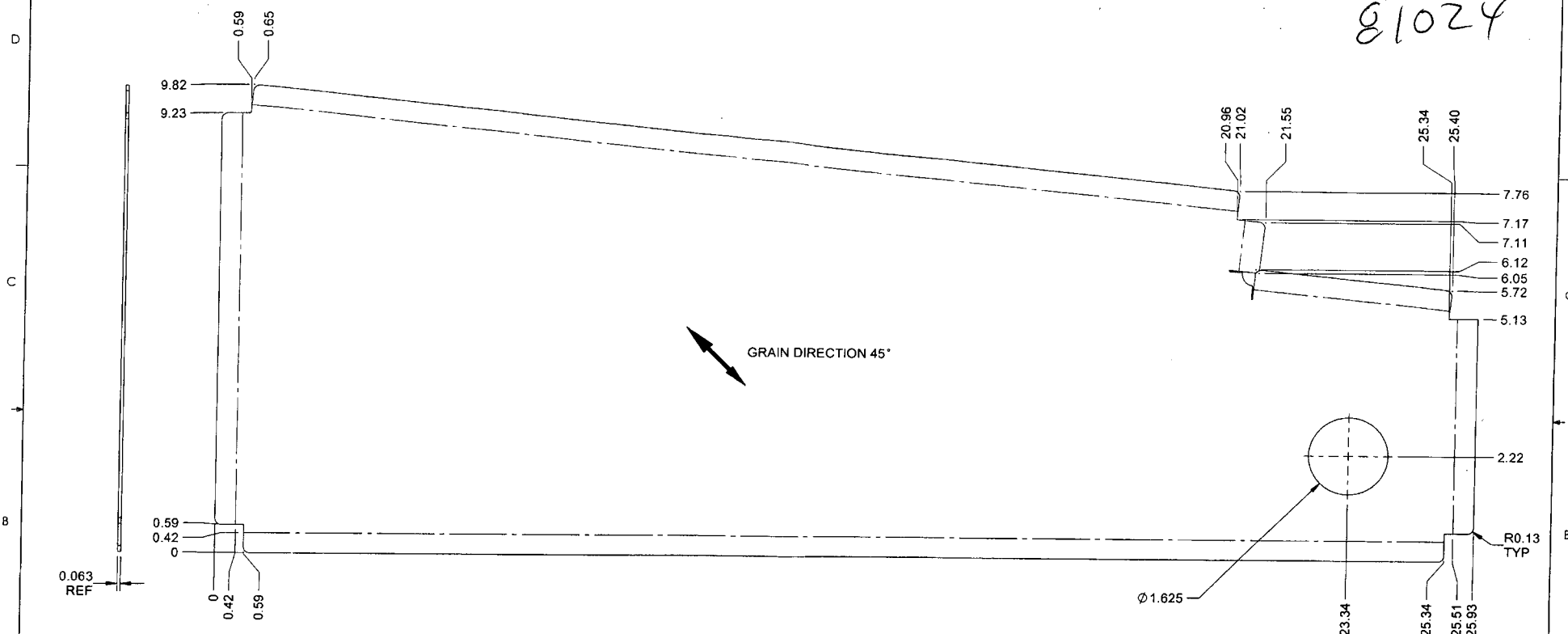
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81024



D4055-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

RELEASED
2012-02-27

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4055	SHEET 7 OF 15
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	TANK	NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

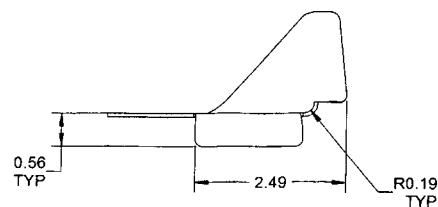
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

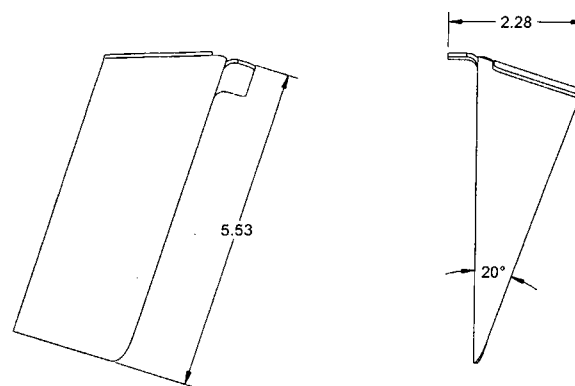
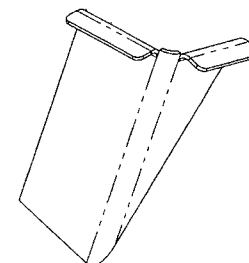
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



81024



D4055-5 UPPER CUT OUT

RELEASED
2012-02-27
MD

- NOTES:
- 1) MATERIAL: MADE FROM D4055-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. D4055	REV. C
MFG. APPR.	JS	SHEET 8 OF 15	
APPROVED	MD	TITLE TANK	SCALE NTS
DE APPR.	MD	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	12.01.20	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

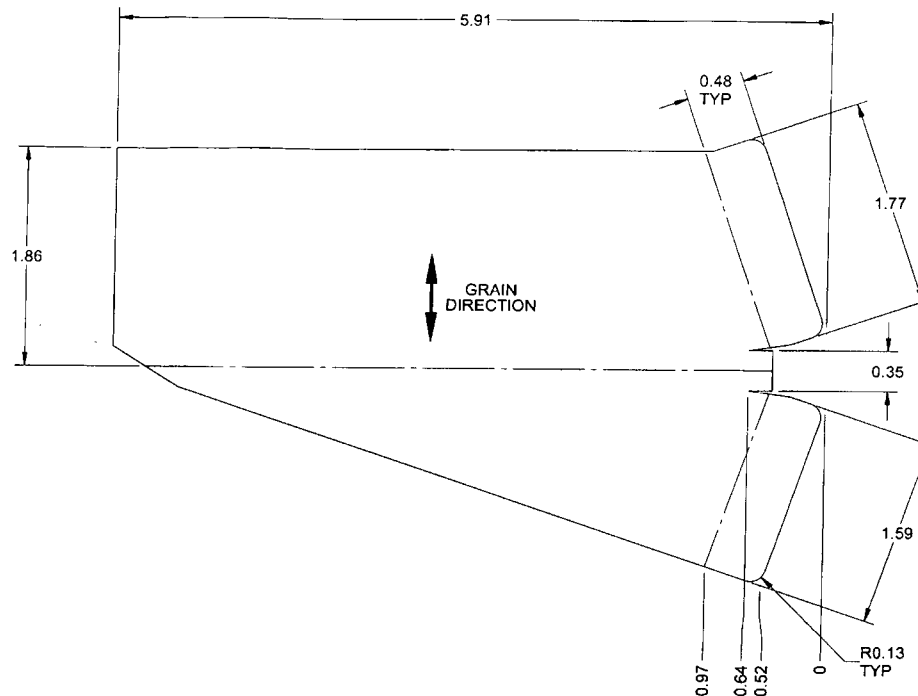
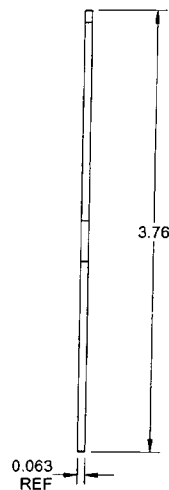
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81024



D4055-5F FLAT PATTERN

RELEASED
2012-02-27

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO. D4055	REV. C
MFG. APPR.	BC	SHEET 9 OF 15	
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	TANK	NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

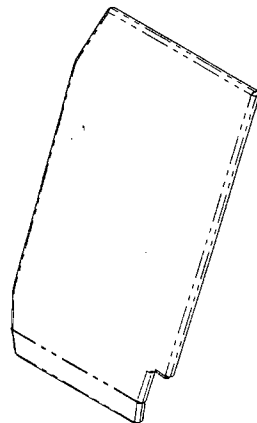
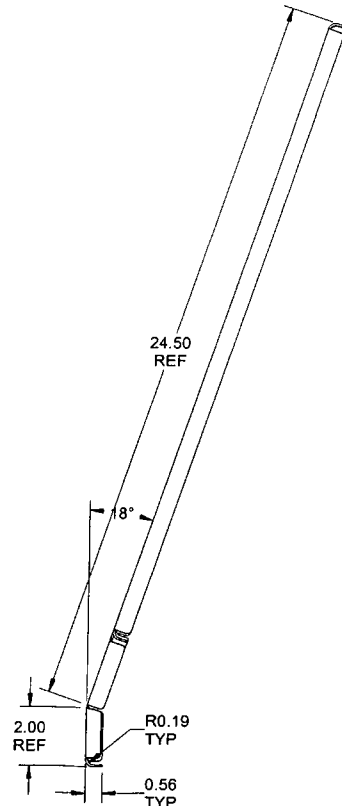
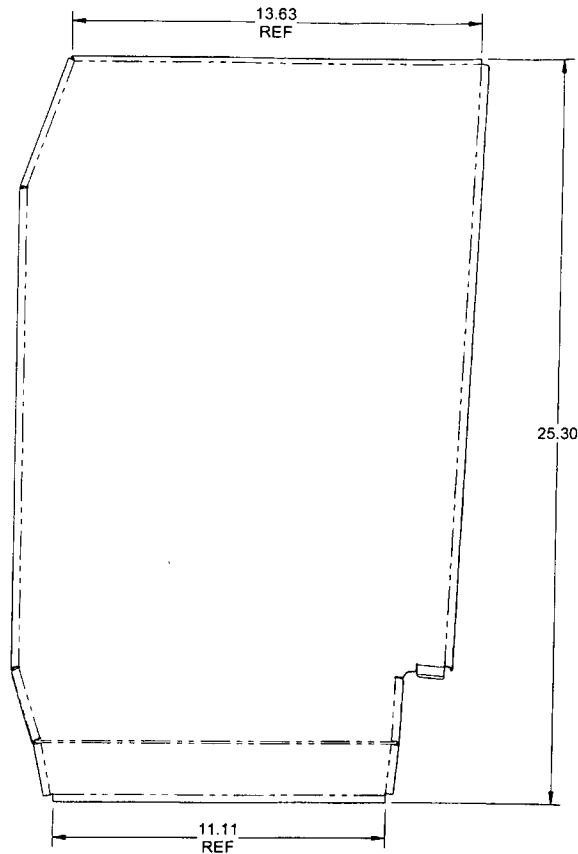
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81024



D4055-7 TANK FORWARD END

NOTES:

- 1) MATERIAL: MADE FROM D4055-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

RELEASED
2012-02-23
JH

DESIGN	JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	JE	DRAWING NO. D4055	REV. C
MFG. APPR.	JE	SHEET 10 OF 15	
APPROVED	JE	TITLE	SCALE
DE APPR.	JH	TANK	NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

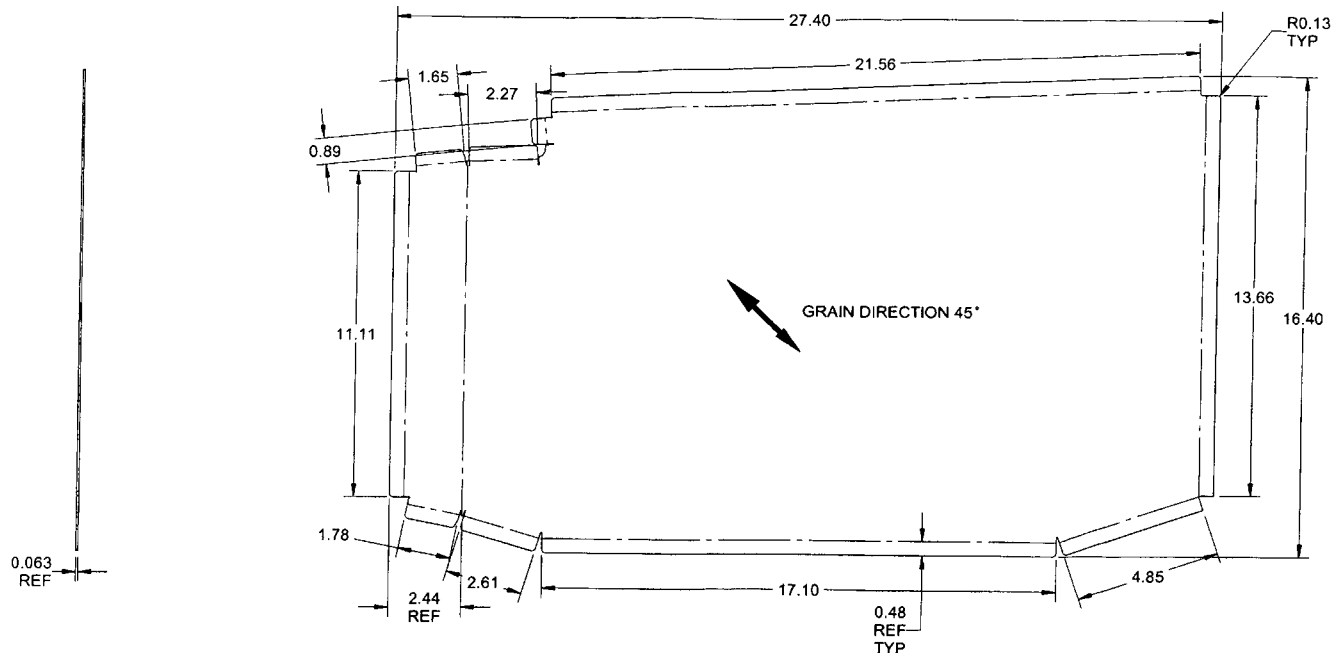
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

21024



D4055-7F FLAT PATTERN

RELEASED
2012-02-27

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.56 lbs

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	E	D4055	SHEET 11 OF 15
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	TANK	NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

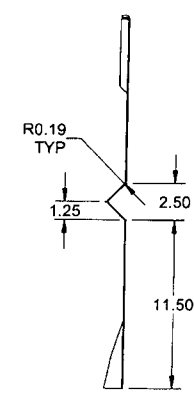
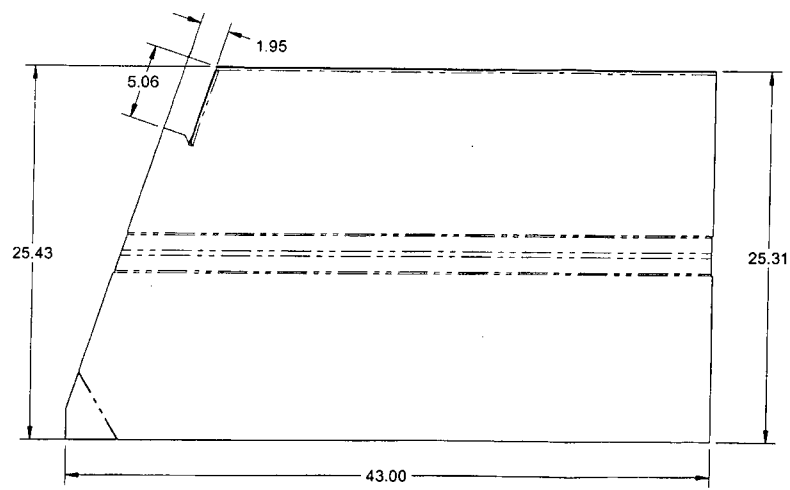
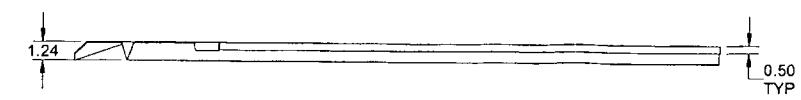
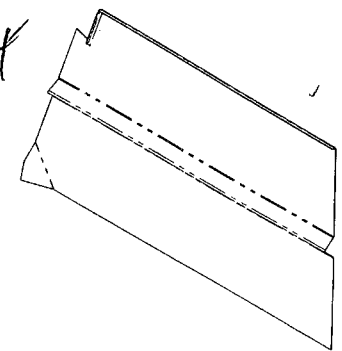
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81024



D4055-9 TANK BACK

RELEASED
2012-02-27

- NOTES:
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	EE	D4055	SHEET 12 OF 15
APPROVED	140	TITLE	SCALE
DE APPR.	14	TANK	NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

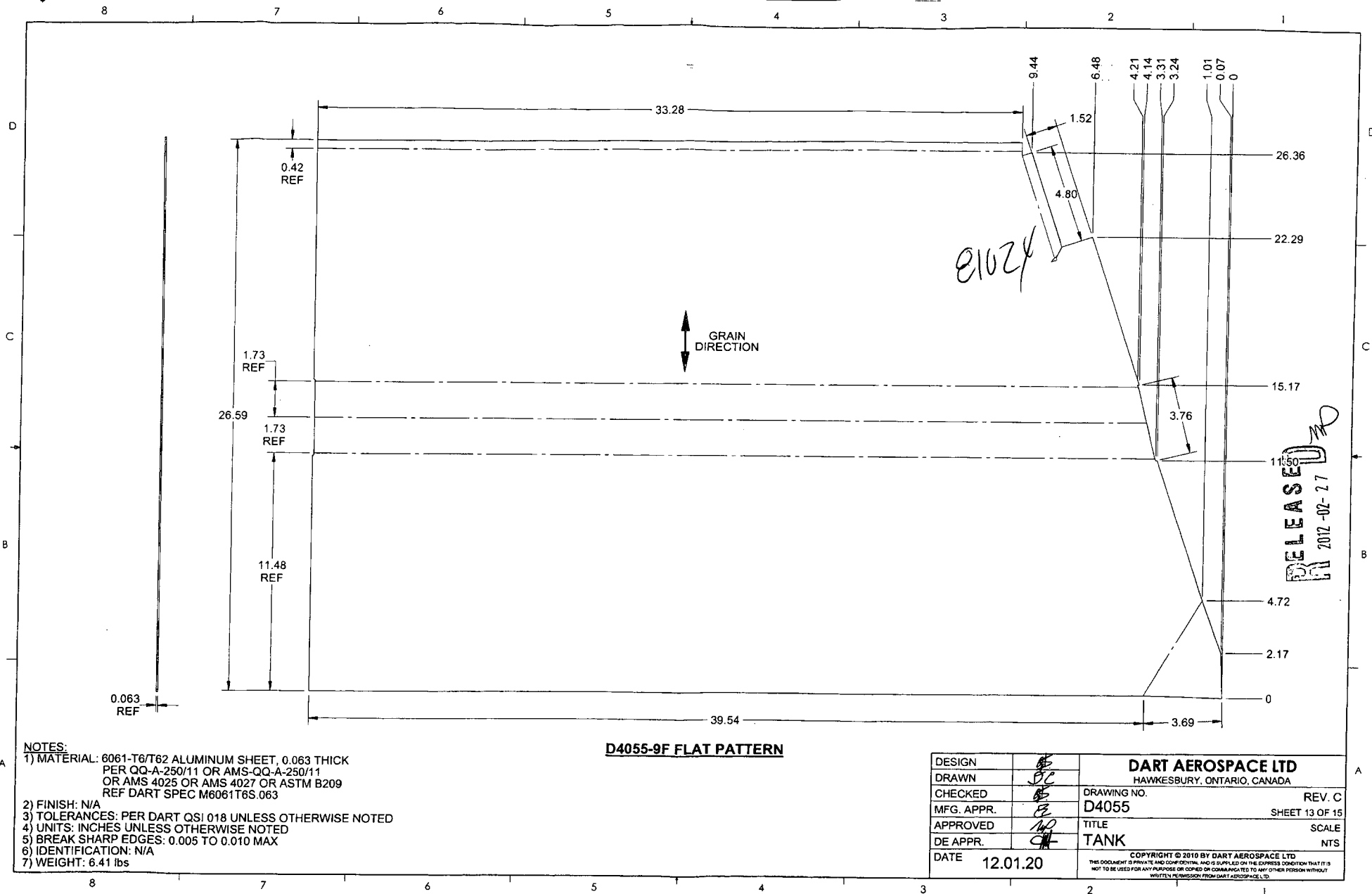
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D4055	REV. C
MFG. APPR.	CE	SHEET 13 OF 15	
APPROVED	AD	TITLE	SCALE
DE APPR.	CH	TANK	NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

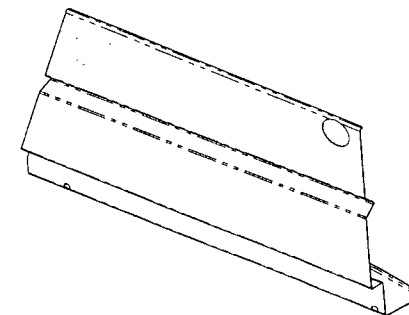
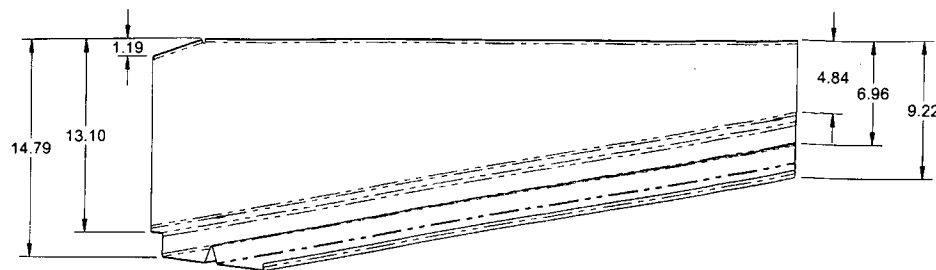
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

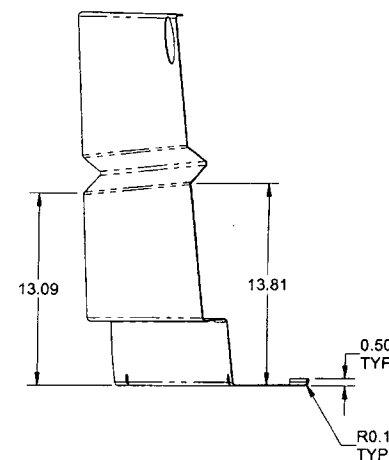
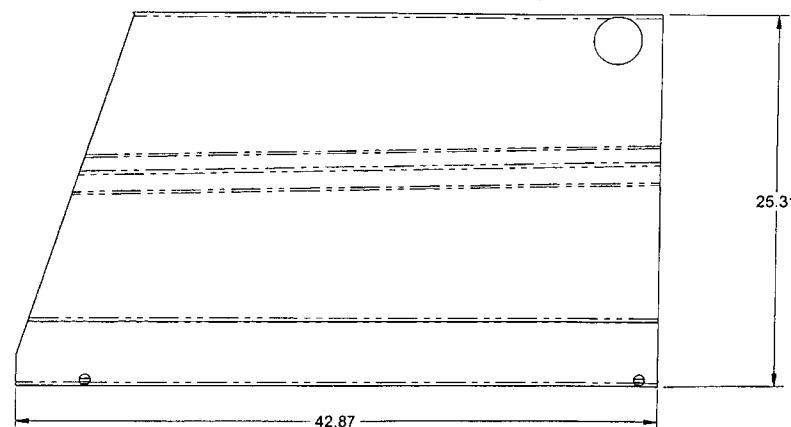
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



81024



D4055-11 TANK FRONT AND BOTTOM

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.32 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4055	SHEET 14 OF 15
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	TANK	NTS
DATE	12.01.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries